

WHAT IS CLAIMED IS:

1. A toner including toner particles comprising a styrene acrylate binder and at least one colorant, and wherein the toner particles, in the absence of external additives, have a mean circularity of from about 0.94 to about 0.98 and a particle size distribution with a lower number ratio geometric standard deviation (GSD) of approximately 1.28 to approximately 1.31 and an upper volume GSD of approximately 1.24 to approximately 1.27.
2. The toner according to claim 1, wherein the binder comprises about 75 to about 85% by weight of the toner particles on a solids basis.
3. The toner according to claim 1, wherein the toner particles further comprise a wax dispersion.
4. The toner according to claim 3, wherein the wax dispersion is present in an amount of about 8 to about 11% by weight of the toner particles on a solids basis.
5. The toner according to claim 1, wherein the toner is a cyan toner, and the at least one colorant is present in an amount of about 5 to about 8% by weight of the toner particles on a solids basis and has a calcium content of from about 1 to about 30 ppm.
6. The toner according to claim 1, wherein the toner is a magenta toner, and the at least one colorant is present in an amount of about 7 to about 15% by weight of the toner particles on a solids basis and has a calcium content of from about 20 to about 220 ppm.
7. The toner according to claim 1, wherein the toner is a yellow toner, and the at least one colorant is present in an amount of about 5 to about 8% by weight of the toner particles on a solids basis and has a calcium content of from about 30 to about 55 ppm.
8. The toner according to claim 1, wherein the toner is a black toner, and the at least one colorant is present in an amount of about 5 to about 8% by weight of the toner particles on a solids basis and has a calcium content of from about 0 to about 30 ppm.

9. The toner according to claim 1, wherein the toner particles further comprise polyaluminum chloride in an amount up to about 2% by weight of the toner particles on a solids basis.

10. The toner according to claim 1, wherein the toner particles further comprise a colloidal silica in an amount up to about 10% by weight of the toner particles on a solids basis.

11. The toner according to claim 1, wherein the toner particles a BET surface area of about 1.3 to about 6.5 m<sup>2</sup>/g.

12. The toner according to claim 1, wherein the toner particles have an average pore diameter is from about 40 to about 70 nm at 4V/S and a total pore volume of about 1.3 to about 1.5 ml/g.

13. The toner according to claim 1, wherein the toner particles have a shape factor of about 110 to about 160 SF<sup>a</sup>.

14. The toner according to claim 1, wherein the toner particles have a triboelectric value of about 40 to about 100  $\mu$ C/g.

15. The toner according to claim 1, wherein the toner particles have a copper content of from 0 to about 80  $\mu$ g/g, a bulk aluminum content of about 500 to about 800  $\mu$ g/g and a sodium content of about 300 to about 600  $\mu$ g/g.

16. The toner according to claim 1, wherein the toner particles further comprise one or more external additives selected from the group consisting of silica, titanium dioxide and zinc stearate.

17. The toner according to claim 1, wherein the toner particles are further mixed with carrier particles.

18. A set of toners for forming a color image, comprising a cyan toner, a magenta toner, a yellow toner and a black toner, wherein each of the cyan toner, the magenta toner, the yellow toner and the black toner comprise toner particles comprised of about 70 to about 95% by weight, dry basis, of a styrene acrylate binder, about 5 to about 15% by weight, dry basis, of a wax dispersion, and at least one colorant, and wherein the toner particles, in the absence of external additives, have a mean circularity of from about 0.94 to about 0.98 and a particle size distribution with a lower number ratio geometric standard deviation (GSD) of approximately 1.28 to

approximately 1.31 and an upper volume GSD of approximately 1.24 to approximately 1.27.

19. The set of toners according to claim 18, wherein the toner particles of the cyan toner have a calcium content of from about 1 to about 30 ppm on a solids basis, the toner particles of the magenta toner have a calcium content of from about 20 to about 220 ppm on a solids basis, the toner particles of the yellow toner have a calcium content of from about 30 to about 55 ppm on a solids basis, and the toner particles of the black toner have a calcium content of from about 0 to about 30 ppm on a solids basis.